

Work Order ID 70297

Thursday, June 02, 2011 1:46:03 PM



Page 1

Item ID: D3204-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Release Pedal Assembly

Start Date: 6/8/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3204

Rev A1

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. 12- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. 13- Use JB weld compound to plug the hole after assembly. 14- Grind JB weld flush after it is cured. Ident

EL 117-11 (X6)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

6 8 BE11/07/11

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5 m07/11

(X6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Date:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6 φ BL 11-7-11

140

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

Cover holes for bushing START TIME:

TIME: OVEN TEMPERATURE: FINISH

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6X φ M-11/07/12

6 φ BL 11-7-12

M 115128

7:30
8:00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: Date:

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Install D3204-7 bushing as shown in Dwg D3204

Signature: [Handwritten Signature] 6/11/07/12 (6)

170



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Signature: [Handwritten Signature] 6/11/07/12

(+6)

180



Identify as per dwg & Stock Location: 6:A

0.00

Packaging

Memo

0.00

Packaging

u/o = 70289 (3x)
u/o = 70604 (3x)

Signature: [Handwritten Signature] 6/11/07/13 (6)

Work Order ID 70297

Thursday, June 02, 2011 1:46:03 PM



Page 4

Item ID: D3204-041

Accept



Setup Start



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Item Name: Release Pedal Assembly

Start Date: 6/8/2011 Start Qty: 4.00



Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/13 *[Signature]*

ME

11-07-13

Picklist Print

Thursday, June 02, 2011 1:45:59 PM

Page 1

Work Order ID: 70297

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly



Start Date: 6/8/2011

Required Date: 6/17/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C:05.08.11 Added Step 25 KJ/JLM:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3204-1 Tube		Manufactured	No			100	Each	12.0000	1	4			
EL 11-7-7.													

Location	Loc Qty	Loc Code
WA	10	
68571	10	
WA019	2	
60883	2	

D3204-11 Plate		Manufactured	No			100	Each	36.0000	1	4			
EL 11-7-7													

Location	Loc Qty	Loc Code
ST45	14	
57522	14	
WA019	22	
55463	22	

D3204-13 Gusset		Manufactured	No			160	Each	12.0000	2	8			
EL 11-7-7													

Location	Loc Qty	Loc Code
WA019	12	
58211	12	

6

6

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, June 02, 2011 1:46:00 PM

Page 2

Work Order ID: 70297

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 6/8/2011

Required Date: 6/17/2011

Start Qty: 4.00

Required Qty: 4.00

D3204-3
Arm
Manufactured No

100 Each 7.0000 1 4



EL 11-7-7

65139X5

Location

Loc Qty

Loc Code

WA019

7

57737

1

D3204-5
Arm
Manufactured No

100 Each 6.0000 1 4



EL 11-7-7

Location

Loc Qty

Loc Code

WA

6

65140

6

D3204-7
Bushing
Manufactured No

100 Each 13.0000 2 8



6
8
6/11/07/12

Location

Loc Qty

Loc Code

ST041

13

60871

13

D3204-9
Pedal
Manufactured No

100 Each 14.0000 1 4



12
EL 11-7-7

Location

Loc Qty

Loc Code

WA

14

65141

4

68573

10

4
2

Thursday, June 02, 2011 1:46:00 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

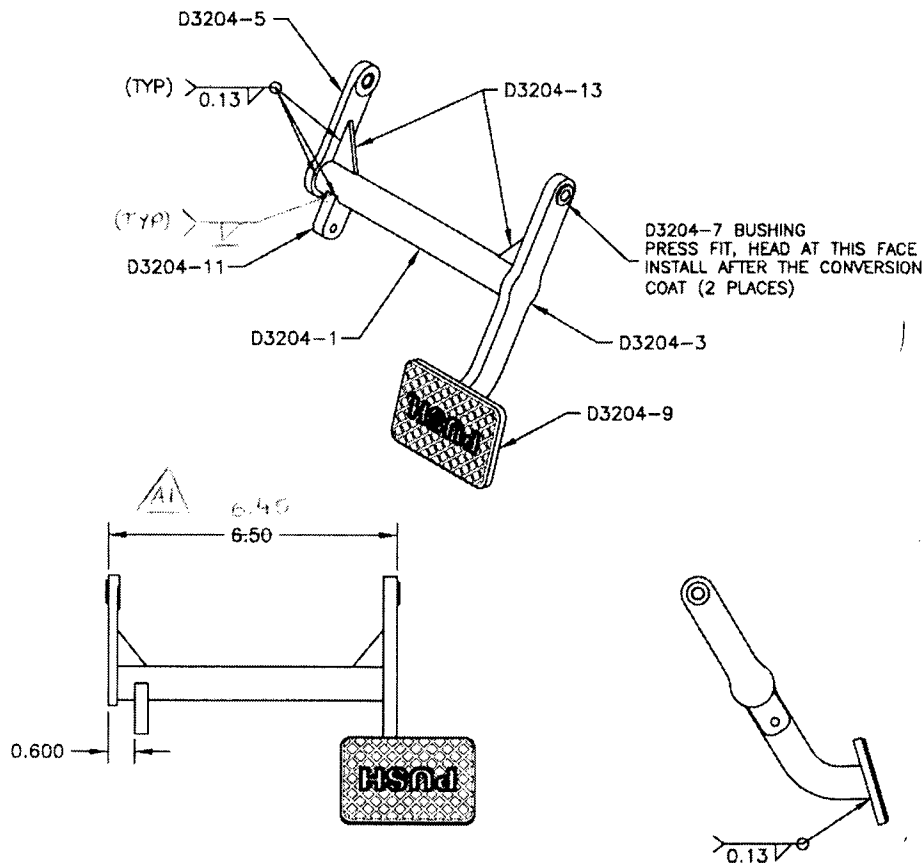
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A	04.01.27	NEW ISSUE	
AI		05 07 15 6.45 WAS 6.50	

RELEASED
04 30 10



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

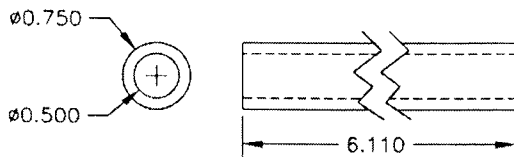
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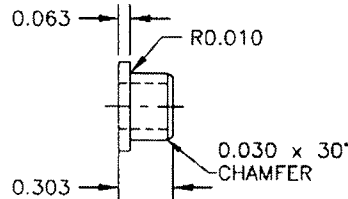


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

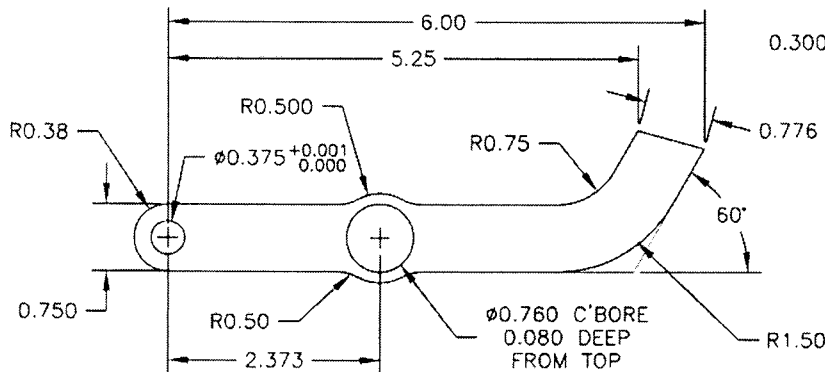
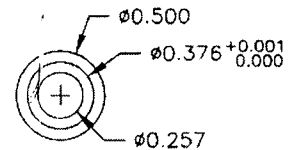
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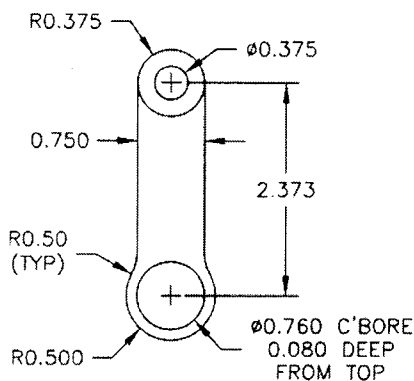
2 D3204-1 TUBE
SCALE 1:2



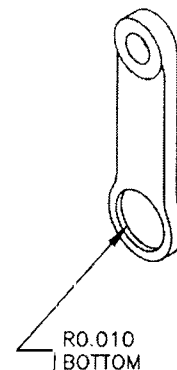
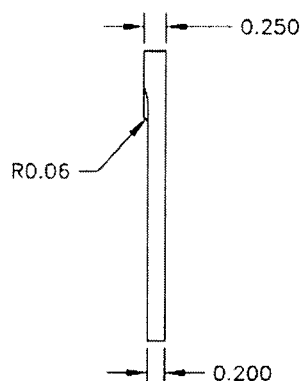
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



7 pages

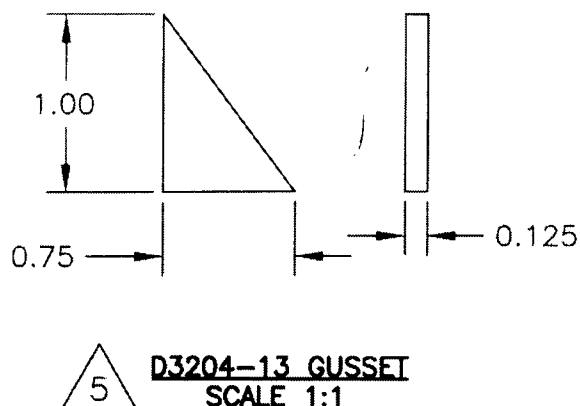
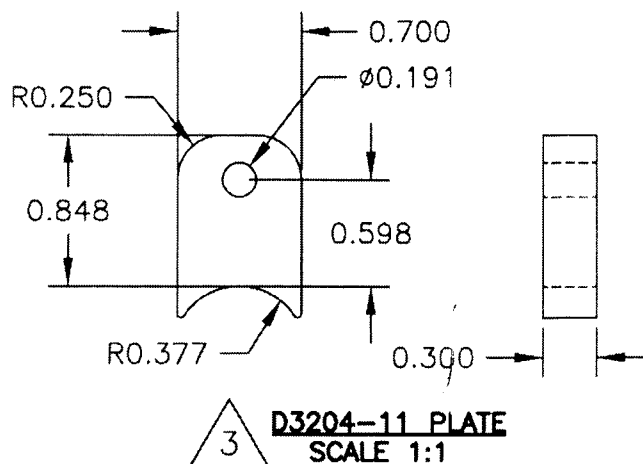
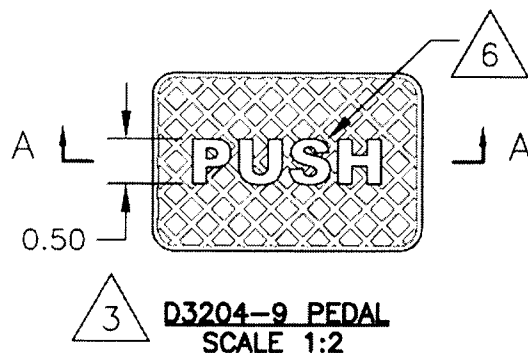
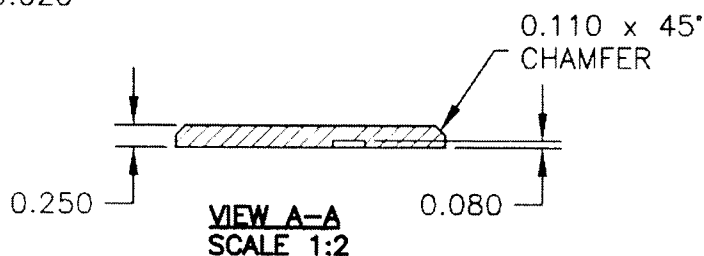
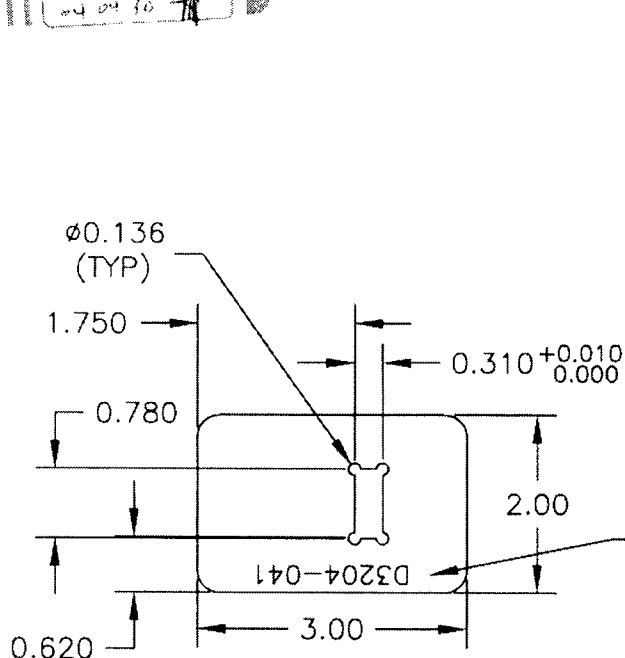
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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

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